

Date: Thursday, 13/03/2008 2:53:00 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D407-667-105
Job Number : 37869	
Estimate Number : 10804	
P.O. Number :	Part Number : D407667105
This Issue : 13/03/2008 S.O. No. :	Drawing Number : RTN FROM HAI
Prsht Rev. : NC	Project Number :
First Issue : 12/03/2008 Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 19/03/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
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Handwritten: 08-03-13 (C)



Comment: INSPECT PART FROM HAI
D407-667-105 B19128 CHG001

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
PULL FROM HAI
1 X D407-667-105 B19128 CHG001

Handwritten: H / EL

DRILL HOLES PER DRWG D407-667-145 REV.B
FOR COMPATABILITY WITH BHT/AA SKIDTUBES

Handwritten: 08-03-17

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 5 08/03/18 (C)

4.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING
RE-SPRAY CUFFS, TOUCH UP AS NECESSARY

Handwritten: 25 08-03-18

5.0	QC14	INSPECT SPRAY PAINT
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Comment: INSPECT SPRAY PAINT

Handwritten: 08 03 19

Handwritten: (C)

Date: Thursday, 13/03/2008 2:53:01 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-105

Job Number: 37869

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

RT 08-03-18

7.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

~~100777~~ 10505712

RT 08-03-18

8.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate 34077

RT 08-03-18

9.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate 36064

RT 08-03-18

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/19 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PICK PACKING KIT:

Date: Thursday, 13/03/2008 2:53:01 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-105

Job Number: 37869

Part Number: D407667105

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105408 20

M106242 20

13.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

14.0	AN510A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Batch: M106519

850000 2710

15.0	AN530A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M105144

16.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M106654

8/3/19

17.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

8/3/20

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP

USING ORIGINAL NEW B/N 37869

CHG 002

SLP (N)

Date: Thursday, 13/03/2008 2:53:01 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-105

Job Number: 37869

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/03/08 ①

Job Completion



u 58-03.20



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH DS	APPROVED PH DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 ~~PH~~

UNDER REVIEW
06.08.10 ~~PH~~
re-draw detail

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

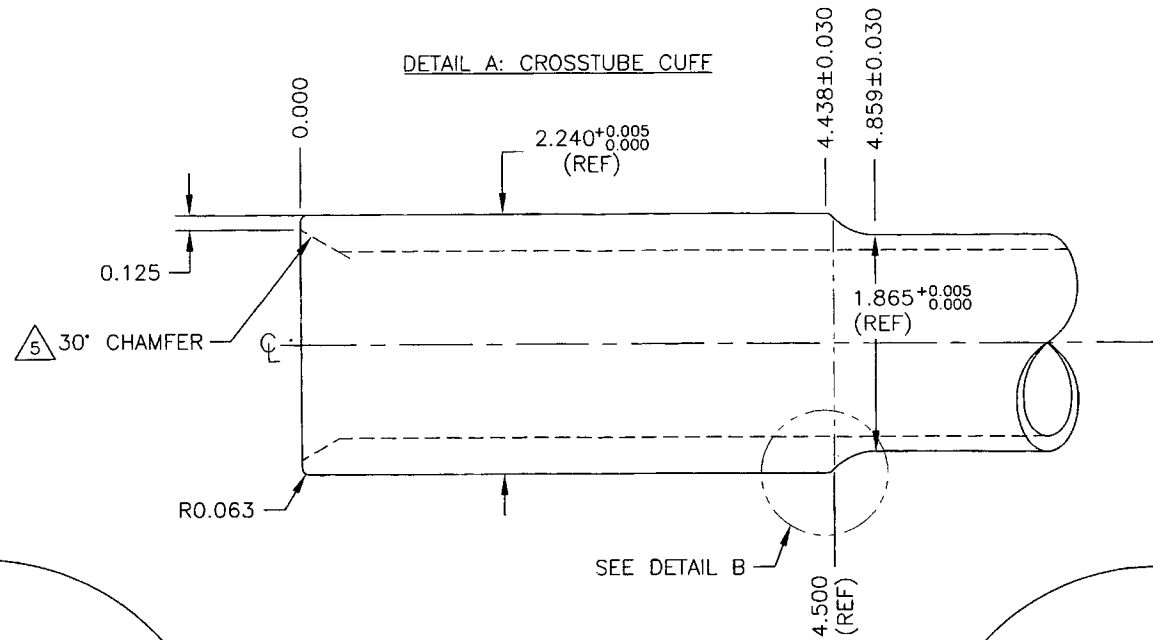
W/O 37869

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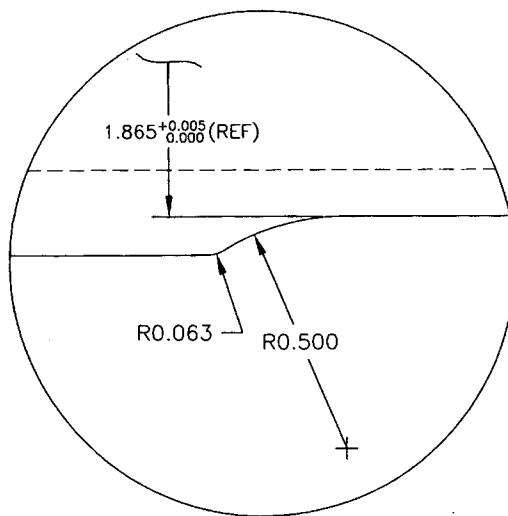
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		CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	REV. # SHEET 2 OF 3
		DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:1

DETAIL A: CROSSTUBE CUFF



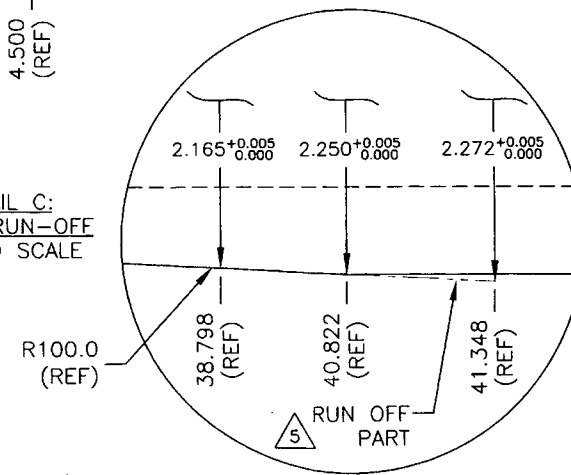
UNDER REVIEW
05.08.10 PH
Re-draw detail F

05.07.26



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. WAINESBURY, ONTARIO, CANADA
CHECKED	DS	APPROVED	DS	DRAWING NO.	REV. B
DATE	05.07.26	TITLE	CROSSTUBE ASS'Y (407 HIGH FWD)	D407-667-145	SHEET 3 OF 3
		SCALE	1:1		

